

Date: Friday, 13/06/2008 1:48:26 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	REPLACEMENT WINDOW ASSEMBLY	
Job Number :	39870	Part Number :	D3290041	
Estimate Number :	11174	Drawing Number :	D3290 REV C	
P.O. Number :		Project Number :	N/A	
This Issue :	13/06/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	C	
First Issue :	/ /	Material :		
Previous Run :	37414	Due Date :	23/06/2008	Qty: 12 Um: Each
Written By :				
Checked & Approved By :	<u>JUD 08.6.13</u>			
Comment :	Est. B 05.05.25 Added Step 11 KJ/JLM Est. C 06.05.09 Ecn 798 EC Est Rev:D Now on Waterjet 06-06-16 JLM Est rev E rev C dwg 07.09.28 EC verified by: DD			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 3.9375 sf(s)/Unit Total : 47.2500 sf(s)

M6061T6S040

Batch: 107461 HB 8-6-16

2.0	WATER JET	FLOW WATER JET
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(PD) =>

Comment: FLOW WATER JET

1-Cut as per Dwg D3290 (use prog. for D3290-1)

Dwg Rev: CProg Rev: C

HB 8-6-16

(12)

2-Deburr if necessary

HB 8-6-16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-6-16

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 08/06/16 (TD)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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(12X)


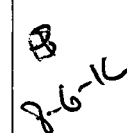
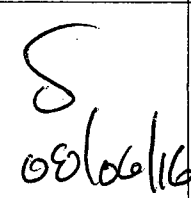

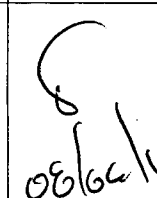
Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. J. 08/06/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3290-041 PAR #: N/A Fault Category: Prod / Process NCR: Yes No DQA: D Date: 08/07/08
D350-567 QA: N/C Closed: D Date: 08/07/08

NCR: <u>39870</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/16	# 2.0	one part scrap. nuts are off when operator left for lunch he left tank on water jet disturbing (bubbling) it		Scrap and Destroy and Part Replace. Qty <u>1</u> B# <u>107461</u>	 8-6-16	 08/06/16		 08/06/16
		moved the sheet. was not noticed in till the part was finished. QC look at attention						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 39870

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



1107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

10:40

OVEN TEMPERATURE:

315

FINISH TIME:

11:10

M. H. A. 21

08/06/18

12X

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.06.19

12

8.0

D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total: 78.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description Batch

1 D2126-0780 Locking Seal

B35251

SAD

08/07/03

12

9.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Window

Pick:

Qty Part Number Description Batch

1 D3290-3 Window

B39873

SAD

08/07/03

12

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SAD 08/07/03

12

PTO

11.0

QC5

INSPECT WORK TO CURRENT STEP





Comment: INSPECT WORK TO CURRENT STEP

SAD 08/07/03

12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/07/03	10.0	Took 5 frames from store with the B#26932 Part # D3290-1	SAN 08/07/03	08/07/03	5		 08/07/03

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/06/2008 1:48:27 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 39870

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 218

JS 08/07/03 *(17)* *u*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/08 *JS*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.07.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39870
Description: Window Frame		Part Number: D3290-1
Inspection Dwg: D3290	Rev: C	Page 1 of 1

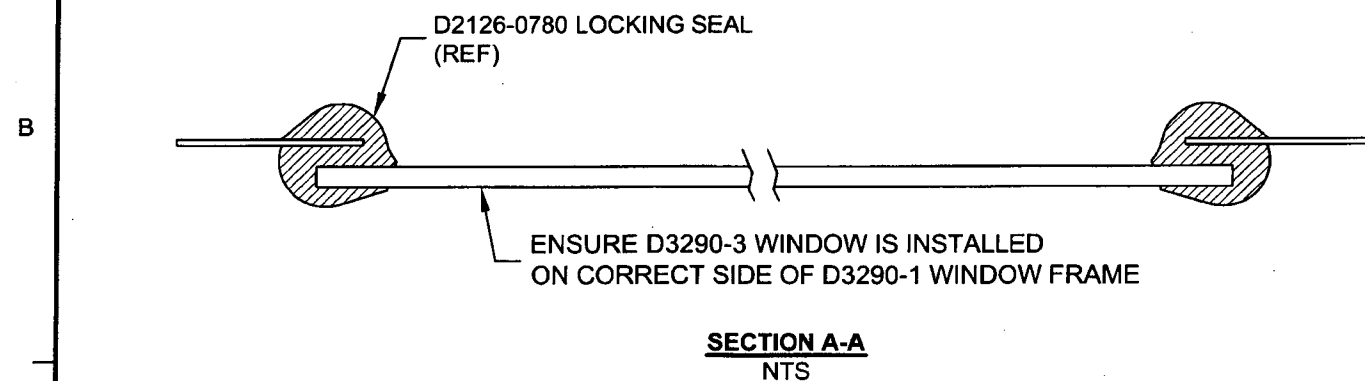
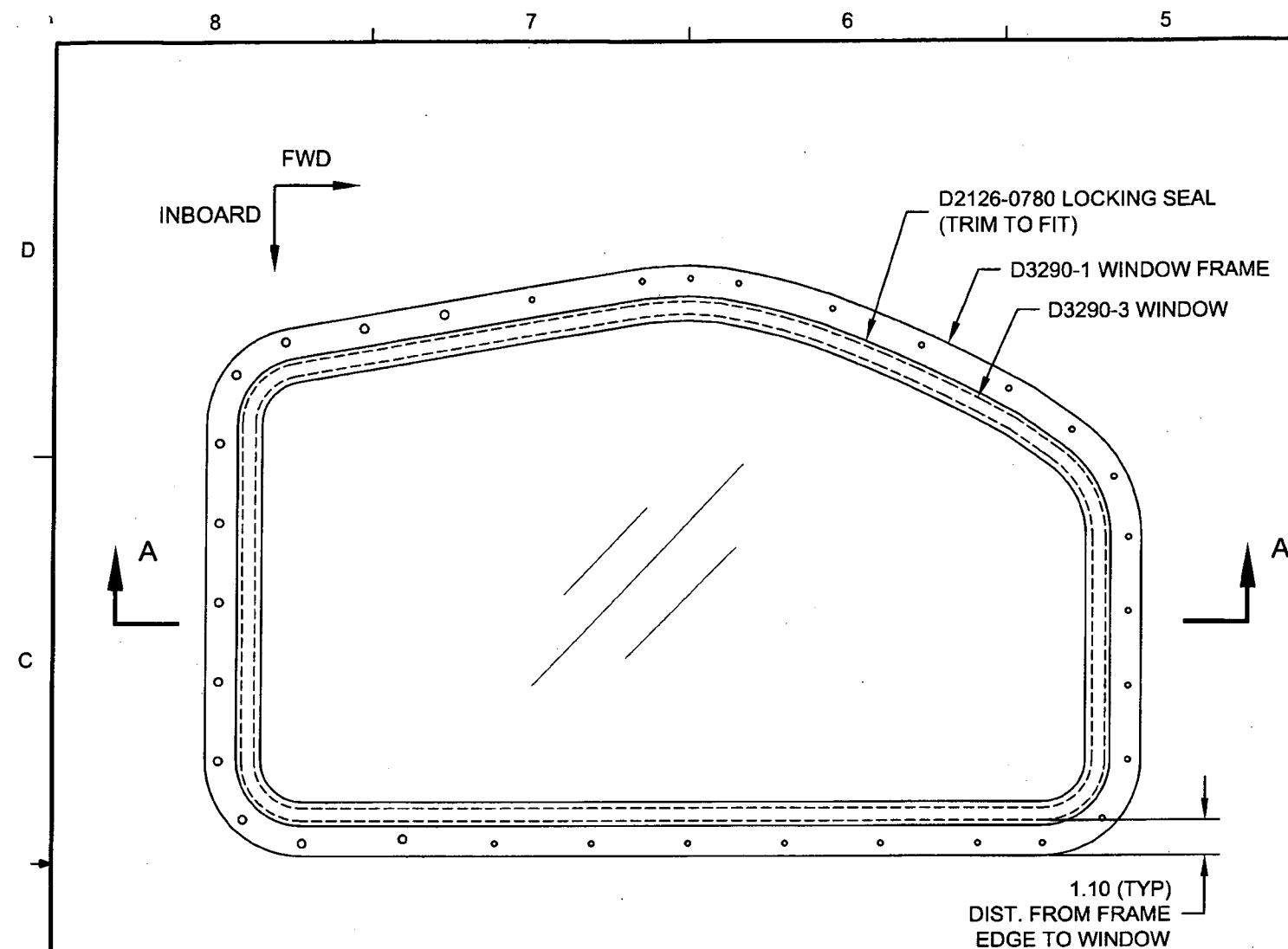
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	X			
14.00	+/-0.030	14.00	X			
Ø0.171	+0.005/-0.001	0.178	X			
1.50	+/-0.030	1.51	X			
1.11	+/-0.030	1.11	X			
10.10	+/-0.030	10.10	X			
18.50	+/-0.030	18.45	X			
0.040	+/-0.010	0.041	X			
R3.00	+/-0.030	3.00	X			
R4.50	+/-0.030	4.50	X			
Ø0.257	+0.006/-0.001	0.264	X			
13.61	+/-0.030	13.61	X			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 8-6-16	Date: 08/06/16	Date:	N/A

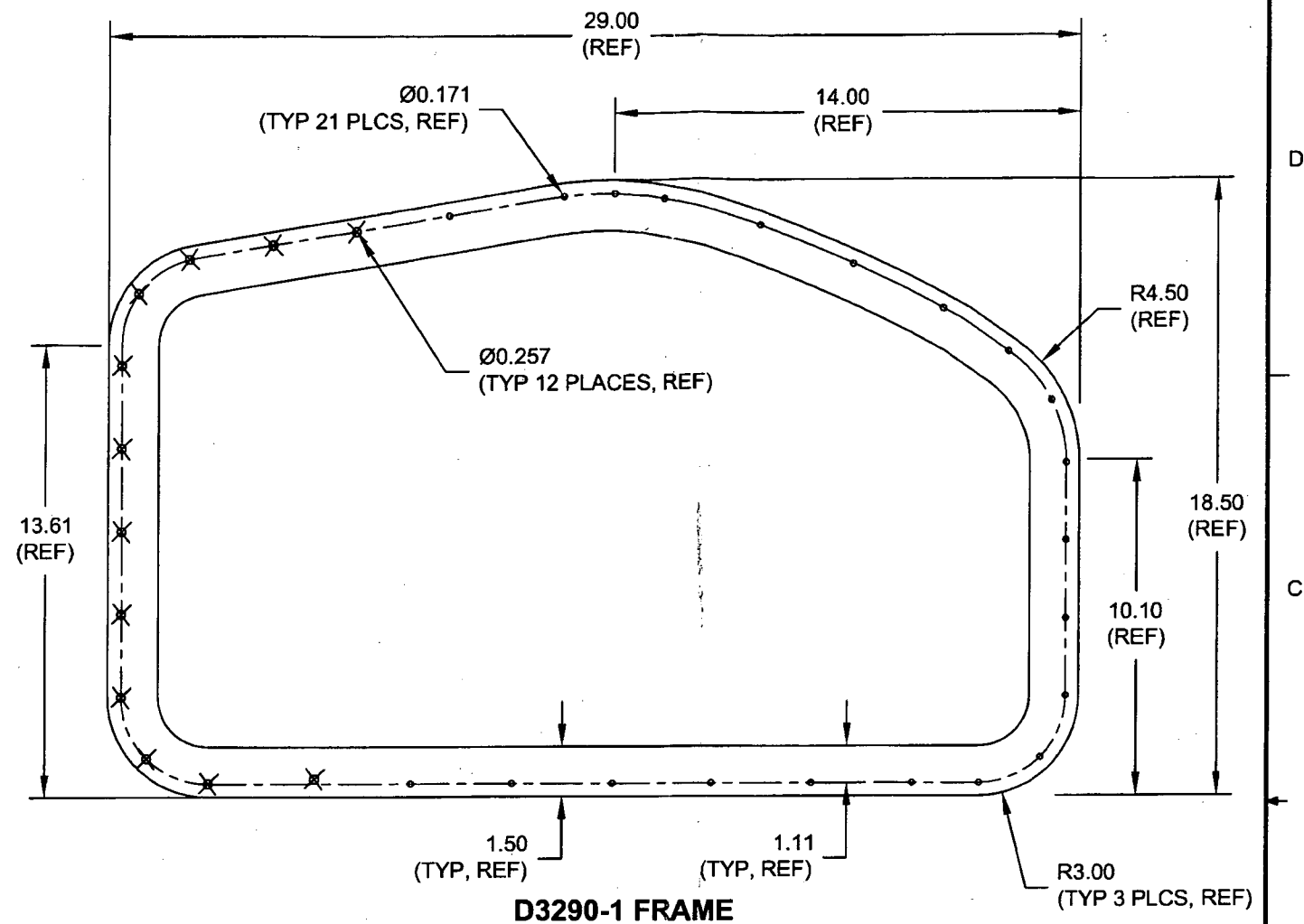
Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue P/O D3290-041	KJ/JLM	
B	07.07.18	13.61 dimension removed	KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C	KJ/EC/DD	BE



D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED



D3290-1 NOTES:

- MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.040)
- FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- WEIGHT: 0.47 LBS

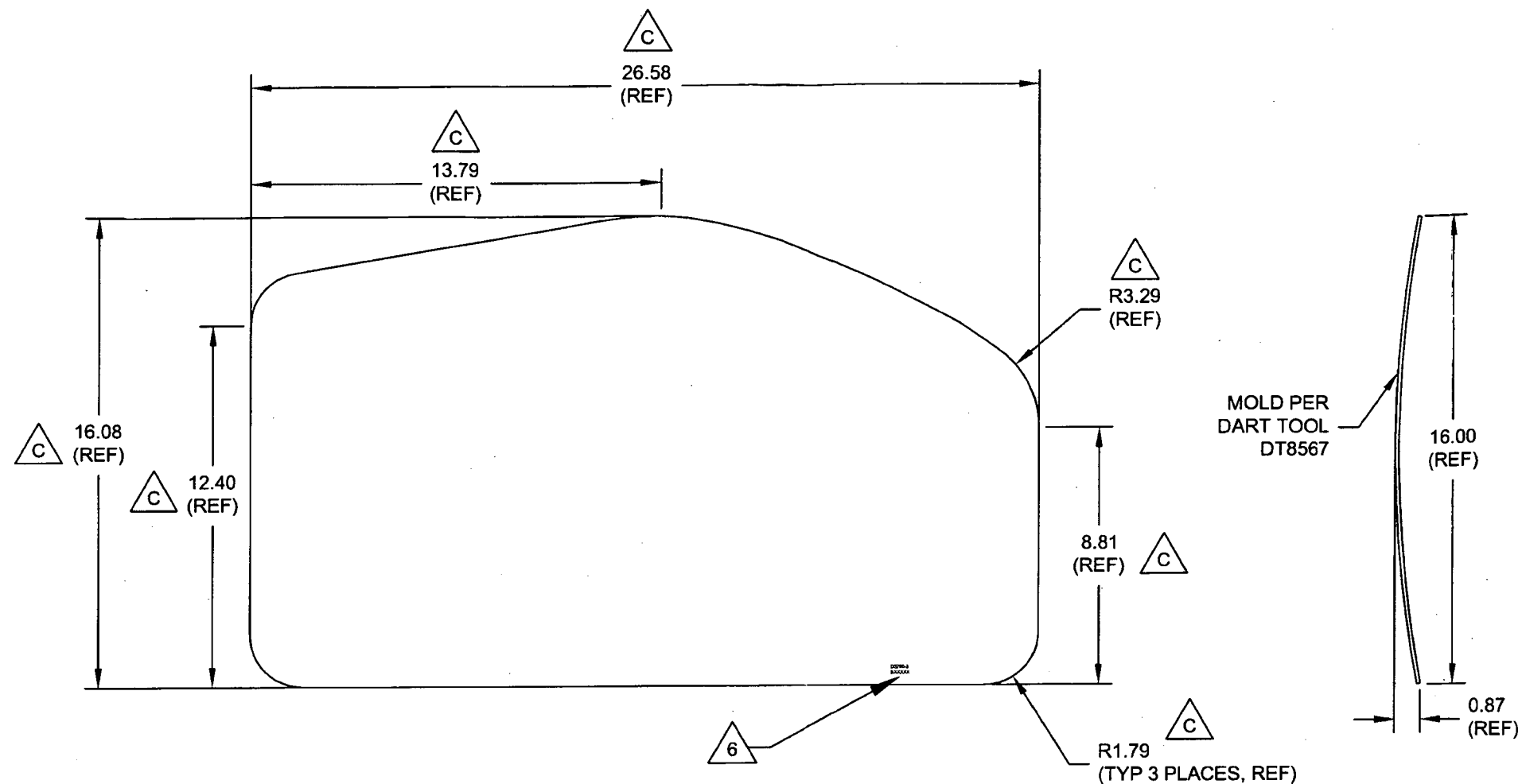
C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. C
D3290 SHEET 1 OF 2
TITLE SCALE
REPLACEMENT WINDOW ASSEMBLY 1:5

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WORK ORDER
NO. 39870



D3290-3 WINDOW

- D3290-3 NOTES:**
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) REMOVE SHARP EDGES
 - 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
 - 7) WEIGHT: 1.87 +/- 0.42 LBS
 - 8) MOLD PER DART TOOL DT8567

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MFG. APPR.	7	D3290	SHEET 2 OF 2
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